

Date: Monday, 12/01/2009 2:34:29 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE
Job Number : 44625	
Estimate Number : 12155	
P.O. Number :	Part Number : D34791
This Issue : 12/01/2009 S.O. No. :	Drawing Number : D3479 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 34087	Material :
Written By :	Due Date : 30/01/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JLD 09.01.13</u>	
Comment : Est Rev:A New Issue 06-02-02 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.1470 f(s)/Unit Total: 0.5880 f(s)

Pick:

304/316 0.018 SHEET

(M304S26GA)

Batch: M109398

EP 09/01/19

2.0	SHEAR	SHEAR
-----	-------	-------

**Comment:** SHEAR

Cut Flat pattern 2.50" X 8.50" as per Dwg D3479

EP 09/01/19

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Roll part as per Dwg D3479

3-Spot weld as per Dwg D3479 and Dart QSI 018

4-Fabricate Bead using Rotary Machine as per Dwg D3479

5-Form as per dwg D3479

FF 09/02/27 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:34:29 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 44625

Part Number: D34791

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 09/03/02

4

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/03/02

4

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 09/03/02

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/02

Job Completion



u 9.03.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

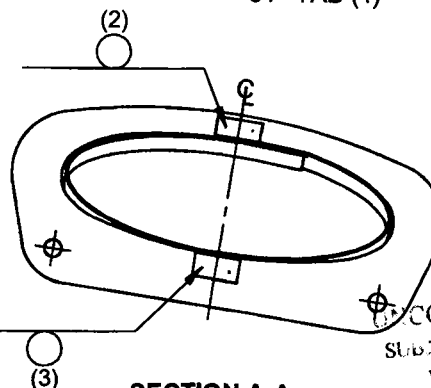
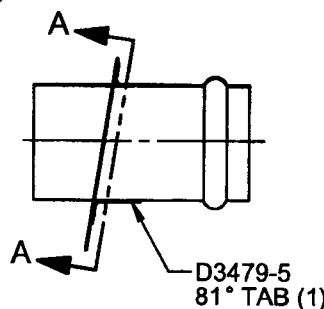
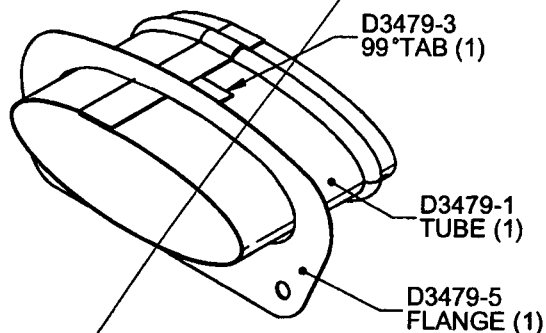
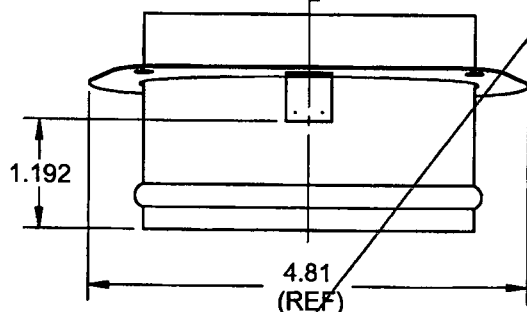
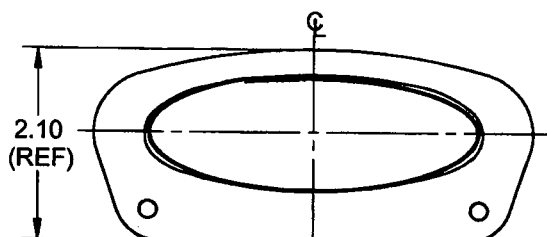
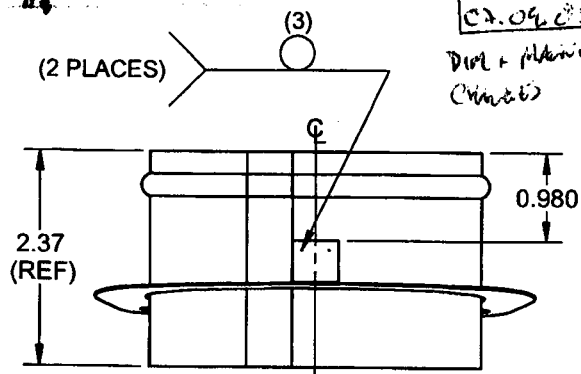


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3479	REV. A SHEET 1 OF 4
DATE 06.01.19		TITLE INLET ADAPTER	SCALE 1:2
A	06.01.19	NEW ISSUE	

[Signature] 06.04.03

UNDER REVIEW

[Signature] 02.04.03
Dart + Manufacturing
(Chassis)



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N44625

D3479-041 INLET ADAPTER

NOTES:

- 1) SPOT WELD PER DART QSI 018
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3479-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

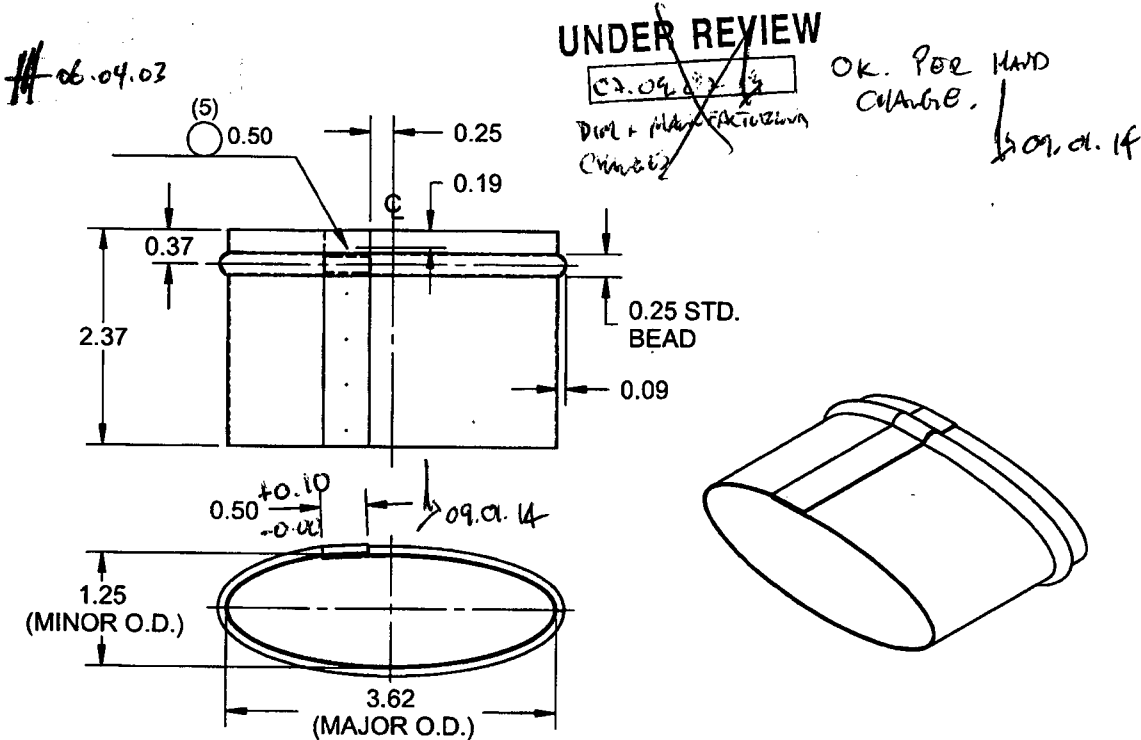
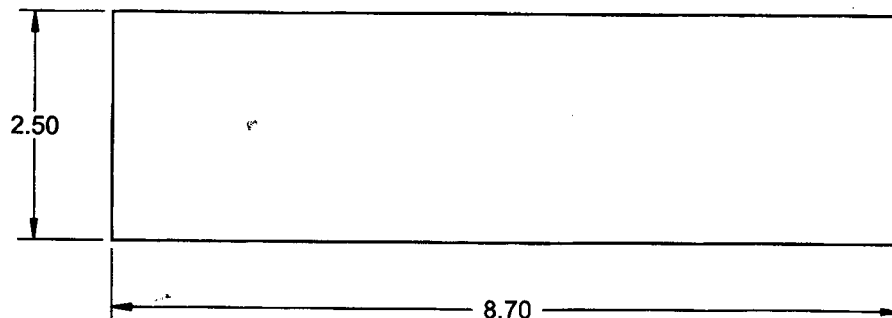
QTY -041	P/N	DESCRIPTION
X	D3479-041	INLET ADAPTER
1	D3479-1	TUBE
1	D3479-3	99 DEGREE TAB
1	D3479-5	81 DEGREE TAB
1	D3479-7	FLANGE

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3479	REV. A SHEET 2 OF 4
DATE 06.01.19		TITLE INLET ADAPTER	SCALE 1:2

**D3479-1 TUBE****D3479-1F FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. *44625*

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 59

EMPLOYEE: Frans Franter

PART NUMBER: D3479-1

JOB NUMBER: B 44625

MATERIAL TYPE: 304 L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION

☐

Group 1: Aluminum & magnesium

☐

Group 2: Iron; nickel; cobalt

☒

Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PENETRATION:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 09/03/02

QUALIFIER: SB